Work Order July-26-12 11:46:		701		*877	′∩1*						Page 1
Revision ID:	0412-698-03.	5		Accept	*N900	040	100)* s	etup Sta	IA	S1* S2*
Start Date: 7 Required Date: 7 Reference:	7/10/12 7/25/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					
Approvals:	Process Plai	n:	Date:	Tooling: SPC (Y/N):		nte:		R	un Sta Sto	, ,,1/1	R1* R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	ision Nbr	^								
IIN D412-698	Rev	E									
*100 *100* DC Document Control		DOCUMENT CONTRO Memo Photocopy	OL SV bluefile & type labels per F	0.00 AS 0.00 9-69 PPP D412-698-032	7 (U) 76 CHG007 U4U7002			<u> </u>	LT 1	2/07	126
110		Pick Kit		0.00							
110 Packaging Packaging		Memo		0.00						ાર	121261 **
120		QC4- 100% Inspect kit	s for completeness	0.00				\sim			
120 QC Quality Control		Memo		0.00 (AS) D/0,126			(a)			

										DQA:	Date:	,	
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	,									QA Closed:	Date:		
Work Order	·:				DISPOSITION				AGAINST DE	PARTMENT	PROCESS		
					Rework			Skid-tube	Crosstube		Water Jet	Engineering	
Part No	o				Scrap		ľ	Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
					Use-as-is		Therm	noforming	Finishing	Rec/Stor	e/Packaging	Other	
NCR No	D				Work Order Update		l	Large Fab	Composite		Supplier		
., .		 	,										
Root		ļ		Descri	ption of work order update	l li	nitial	Ac	tion	Sign &			
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspect	or
Doc/Data													
Equip/Tooling									!				
Operator											··		
Material							:						
Setup													
Other													

Landing Gear General Bending Bend Grain Pressure/Forced Ovalized Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Temperature/Cure Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Folio **Outside Dimensions** Wave/Twist in Tube

FAULT CATEGORY

Process Supplier Training Unapproved

Work Orde July-26-12 11:4		701		*877	7 01*					Page 2
Item ID: Revision ID: Item Name:	D412-698-03 Door Handle	35		Accept	*N900	040	100	* s	Setup Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	7/10/12 : 7/25/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:				
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		ate: ate:		F	Run Start Stop	*NR1* *NR2*
Sequence ID/ Work Center I 130 *120* Packaging Packaging	D	Operation Description Packaging Memo Identify and 035Location	pack for shipping as per		Tool ID	Tool #	Plan Code	Accept Qty		Reject Insp. Number Stamp
140 *140* QC		QC21- Final Inspection	- Work Order Release	0.00					MUJ	2/03/26

Memo

Quality Control

MUS 12 107 126 MW 07-26

										DQA:	Date:	
NCR:	Yes / No				WORK ORDER NON-C	100	VFORM	MANCE / UPDA	ATE			
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Work Orde	ar.				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIR Old					Rework	1		Skid-tube	Crosstube]	Water Jet	Engineering
Part N	No.				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is			noforming	Finishing	4	re/Packaging	Other
NCR I	No				Work Order Update			Large Fab	Composite		Supplier	
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	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre No	ot Concer	ntric to (o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/Un	clear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		-

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

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											DQA:	Dat	æ:	•
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											QA Closed:	Dat	te:	
Work Orde	or.				DISPOSITION				AGAINST D	ΕI	PARTMENT	/PROCESS		
Work Orac					Rework	1		Skid-tube	Crosstube	٦		Water Jet	\neg	Engineering
Part N	No.				Scrap	1	i	Machining	Small Fab	┪	Pro	d. Eng. Coor.	ᅦ	Quality
	***				Use-as-is	1		noforming	Finishing	٦		re/Packaging		Other
NCR N	No				Work Order Update]		Large Fab	Composite			Supplier		
Root	-	1		Descri	tion of work order update	Т	nitial	Ac	tion	٦	Sign &		\neg	
Cause	Date	Step	Qty		or Non-conformance	1	ief Eng		ription	١	Date	Verification	n	QC Inspector
Doc/Data										7				
Equip/Tooling														·
Operator													ı	
Material														
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Process					λ.									
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			. ,		F	ΑŲΙ	T CATE	GORY						
Landi	ng Gear				General		_		_					
	Bending				Bend		Grain		L		Ovalized		L_	Pressure/Forced
	Centre N	ot Concei	ntric to (o/s	BOM/Route		Hardwa	re	L		Over/Under	tolerance		Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete	Ĺ		Part Incorre	ct		Weld
•	Crushed/	Crimped.			Burrs		Instruct	ions Incomplete	/Unclear		Part Lost/Mi	issing		Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance			Part Moved	·		-
	Heat Trea	at		[.	Countersink		Mislabe	led	Γ		Positioned V	Vrong		_
	Inspectio	n Strip in	Tube		Cut Too Short	Г	1 Misreac	Í			Power Loss/	Surge	\Box	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

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July-26-12 11:46:22 AM

Work Order ID:	87701									
Parent Item:	D412-698-035						Start 1	Date: 7/10/12		Required Date: 7/25/12
Parent Item Name:	Door Handle						Start	Qty: 1.00		Required Qty: 1.00
MS21042L3 Nut		Purchased	No		120	Each	3,854.0000	12	12	J.
				Location	Loc Qty		Loc Code			•
				316	906					•
				122452	906					· .
				ST300	948					
				117885	32			-		· · · ·
				119017	725					·
				119075	138			-/-		
				121444	53			12		ž
,				ST317	2000					
				122141	2000					. ,
MS24694-S51		Purchased	No			Each	53.0000		12	12/26/26

Loc Oty

53 53

Location

116805

ST289

12

Loc Code

									DQA:	Date:	4
NCR: Yes	s / No			WORK ORDER NO	N-CO	NFORM	MANCE / UF	•	QA Closed:	Date:	Ne .
Work Order:				DISPOSITION				AGAINST DEI	PARTMENT	/PROCESS	
Part No.				Rework Scrap Use-as-is	ıП	ľ	Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet	Engineering Quality Other
NCR No.	•			Work Order Update	—	1	Large Fab	Composite	Recystor	Supplier	Other
Root				Description of work order updat	te	Initial	A	ction	Sign &		
Cause	Date	Step	Qty	or Non-conformance	CH	nief Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data						-					
Equip/Tooling				1							
Operator									'	·	
Material											
Setup											
Other											
Process]										
Supplier											
Training]									•	
Unapproved											
					FAU	LT CATE	GORY				
Landing	Gear			General			<u> </u>				

nding	Gear		General	 		_	 <u>-</u>
	Bending		Bend	Grain		Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	L	BOM/Route	Hardware		Over/Under tolerance	Temperature/Cure
L	Cracks		Broken/Damaged	Inspection Incomplete	L	Part Incorrect	Weld
L	Crushed/Crimped.		Burrs	Instructions Incomplete/Unclear		Part Lost/Missing	Wrong Stock Pulled
L	Cuffs		Contamination	Maintenance		Part Moved	_
	Heat Treat		Countersink	Mislabeled		Positioned Wrong	 _
L	Inspection Strip in Tube	Ĺ	Cut Too Short	Misread		Power Loss/Surge	Other
L	Ripples in Bend		Drill Holes	Offset			
	Torque Waves in Extrusion		Drawing	Out of Calibration			
L	Turning Sequence		Finish	Out of Sequence			
- [Wave/Twist in Tube		Folio	Outside Dimensions			

IIN-D412-698 Page 25 of 25

8.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 412-030-300-XXX COMPOSITE DOORS)

Qty	Qty	Qty	Qty -032	Qty -033	Qty -035	Part Number	Description
-019	-021	-031	-032	-033	-035	D412-698-019	BEARING OVERHAUL KIT
X						D412-698-021	REPLACEMENT SHIM KIT
	Х					D412-698-021	CABIN DOOR ROLLER KIT, LH
		X					CABIN DOOR ROLLER KIT, EIT
ļ			X			D412-698-032	REPLACEMENT DOOR TRACK KIT
				X		D412-698-033	
					X	D412-698-035	DOOR HANDLE KIT
7						D3121-21	BOLT
5						D3121-241	BEARING ASSEMBLY
 1						D3137-3	GUIDE
 						D3137-5	WASHER
2	· · · · · · · · · · · · · · · · · · ·					D3183-045	BEARING ASSEMBLY
						D0000 4	SHIM
	3				ļ	D3238-1	SHIM
	1					D3238-3	
	2					D3238-5	SHIM
	6					D3238-11	SHIM
	2					D3238-13	SHIM
	4					D3238-15	SHIM
		1				D3121-143	BRACKET ASSEMBLY
-			1			D3121-144	BRACKET ASSEMBLY
		1	1			D3137-043	BRACKET ASSEMBLY
		1				D3183-043	BRACKET ASSEMBLY
		· · -	1			D3183-044	BRACKET ASSEMBLY
		1	1	1		D3202-3	COVER
		3	3	<u> </u>		D3674-041	BRACKET ASSEMBLY
	-	9	9	9		D3675-1	BRACKET
					2	-D3779-041	HANDLE ASSEMBLY
				l	\leq_2^2	D3779-041-	PLATE
ļ	 		<u> </u>	ļ	1/2	D3779-043_/	HANDLE ASSEMBLY
					/ 12	AN525-832R8	SCREW
					/ 12	AN960JD10L	/WASHER
					12-	-MS21042[3	NUT
					12	MS24694-S58	SCREW
1						MS24694-S101	SCREW

REFERENCE ONLY

DART SERVICE INSTRUCTION TO AMEND INSTALLATION INSTRUCTIONS

TO AMEND INSTALLATION INSTRUCTIONS
IIN-D412-698 REV. E OR EARLIER AND INSTRUCTIONS FOR
CONTINUED AIRWORTHINESS ICA-D412-698 REV. 5 OR EARLIER

REF CANADIAN STC: SH92-43 REF FAA STC: SR01446NY REF EASA STC: EASA.IM.R.S.00709 REF ANAC-BRASIL STC: 2010S10-09

1.0 PURPOSE

Field installations have shown that the screws used to mount D3779-041 Exterior Door Handles as part of the D412-698-035 Door Handle Kit are too long. The MS24694-S58 screws that were originally provided in the kit should be replaced with MS24694-S51 screws.

2.0 CHANGE:

8.0 PARTS LIST - CABIN DOOR MODIFICATION KITS (IIN-D412-698) 52.18 PARTS LIST - CABIN DOOR MODIFICATION KITS (ICA-D412-698)

QTY -035	P/N	DESCRIPTION
Х	D412-698-035	DOOR HANDLE KIT

<u>IS:</u>

MS24694 S51	SCREW		

WAS:

12	MS24694-S58	SCREW

NEW ISSUE

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 1/8 (DE # 02)

DATE: 12.04.26
CERT. NO.: SH92-43
ISSUE NO.: 5

REV.		DESCRIPTION	BY	DATE		
DESIGN	RP	DART AEROSPACE LTD				
DRAWN	RP	HAWKESBURY, ONTA				
CHECKED	al	DRAWING NO.		REV. A		
MFG. APPR.	2	DSI 9609		SHEET 1 OF 2		
APPROVED	MA	TITLE EXTERIOR DOOR HANDL		SCALE		
DE APPR.	-##	KIT UPDATI		NTS		
DATE 12	.04.26	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.				

RP

12.04.26

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Change Record

PAGE 1 OF 1

Part Number:

D412-698-035

Description:

DOOR HANDLE

CHG#	DATE	BY	RELEVANT DOCUMENTS	ECN#
001	08.07.01	KJ	DR-D412-698 REV. J	1207
002	12.07.25	KJ	DSI 9609 REV. A, D3779 REV. C	12-580
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·		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

										QA Closed:	Date	
Work Order:						DISPOSITION		AGAINST DEPARTMENT/PROCESS				
Part No					Rework Scrap Use-as-is Work Order Update	Ther	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite		Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other	
Root					Descri	ption of work order update	Initial	I A	ction	Sign &]	
Cause		Date	Step	Qty		or Non-conformance	Chief En		cription	Date	Verification	QC Inspector
Doc/Data			•			· · · · · · · · · · · · · · · · · · ·			<u> </u>			
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Process												
Supplier												
Training											:	
Unapproved												
						F	AULT CAT	EGORY				
Landi	ng G	ear				General				•		<u> </u>
	Ш	Bending	- - 		Grain	Grain Hardware		┩ ┡┩ `		Pressure/Forced		
	Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat BOM/Route Broken/Damaged Contamination Countersink		o/s	- i	Hardw					Temperature/Cure		
				Broken/Damaged		Inspection Incomplete		Part Incorrect Weld		⊣		
			—	Instructions Incomplete/Unclear		Part Lost/Missing Wrong Sto		Wrong Stock Pulled				
			Contamination	Maint	Maintenance		Part Moved					
			Mislat	Mislabeled		Positioned Wrong						
		Inspection Strip in Tube				Cut Too Short	⊢	Misread Power Loss/Surge		'Surge	Other	
	-	Ripples in Bend Drill Holes			4	Offset						
		Torque W			n L	Drawing	\vdash	Calibration				
		Turning S				Finish	Out of	Sequence				
	Wave/Twist in Tube			e		Folio	Outsic	le Dimensions				

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